

Date: Wednesday, 6/27/2007 1:07:14 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STEP STRUT	
Job Number	33205				
Estimate Number	11938				
P.O. Number	N/A		Part Number	D2017123	
This Issue	6/27/2007	S.O. No.	S.O. No.	Drawing Number : D2017 REV E1	
Prsht Rev.	NC			Project Number : N/A	
First Issue	N/A	Type	SMALL /MED FAB	Drawing Revision : E1	
Previous Run	N/A			Material	N/A
Written By			Due Date	7/10/2007 Qty: 6 Um: Each	
Checked & Approved By	<u>JH</u> 07.06.28				
Comment	Est D 02.06.19 Update processes (Ref. ECN 435) KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
Comment: Qty.: 1.1550 f(s)/Unit Total : 6.9300 f(s) Punch tube type 304-2B, $\frac{3}{4}$ " Ø. X .049" wall to length per Dwg. D2017 & spec control D2638 Batch No. <u>M104862</u> SF 07-07-06 6		
		Deburr
2.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP SAP 07/07/09 (6)		
3.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING M 101575 (6) Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 BL 07-07-10		
4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT P-77/11 (6)		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock ST205 / P-77/16 (6) 4 Location: <u>ST205 / P-77/16</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP STRUT

Job Number: 33205

Part Number: D2017123

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.16 KJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



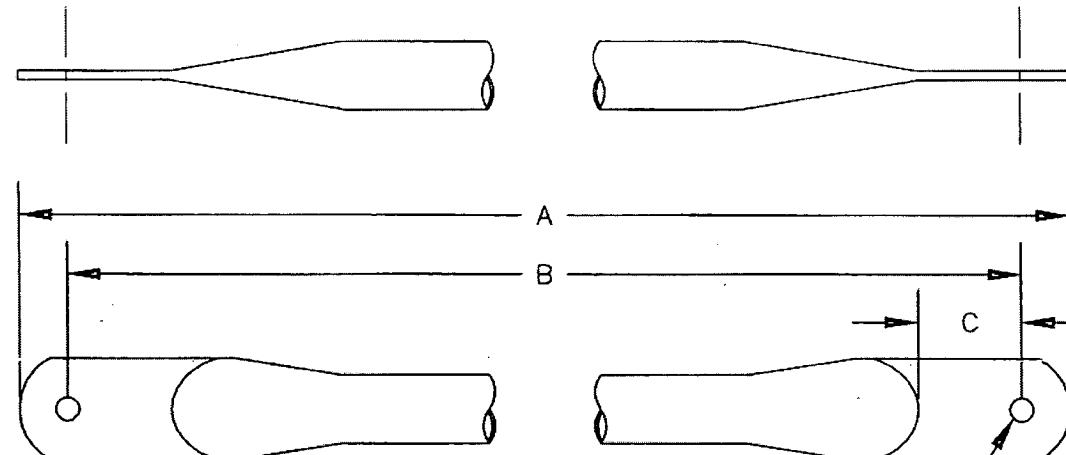
U 07.07.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

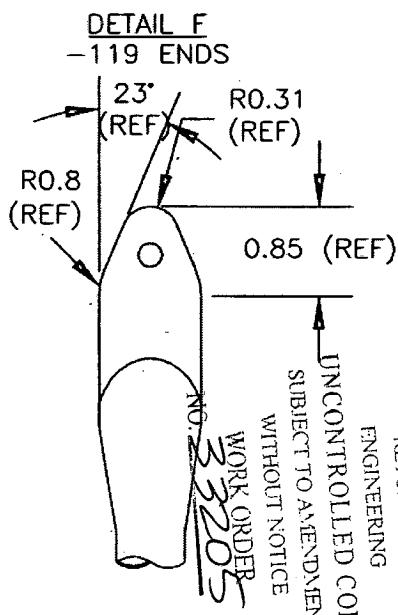
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)



NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)
BEND FLARED ENDS 8° UP / 8° DOWN

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 E1

RELEASED

R 94.05.11 KCE

DART



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED MM	DRAWING NO. D2017	SHEET 1 OF 2
DATE 99.04.16	TITLE STEP STRUTS	NTS	SCALE
C	95.01.26	ADDED PARTS	
D	96.03.28	ADD PARTS	
E	99.04.16	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897)	
E1	02.03.22	ADD FINISH	

Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-

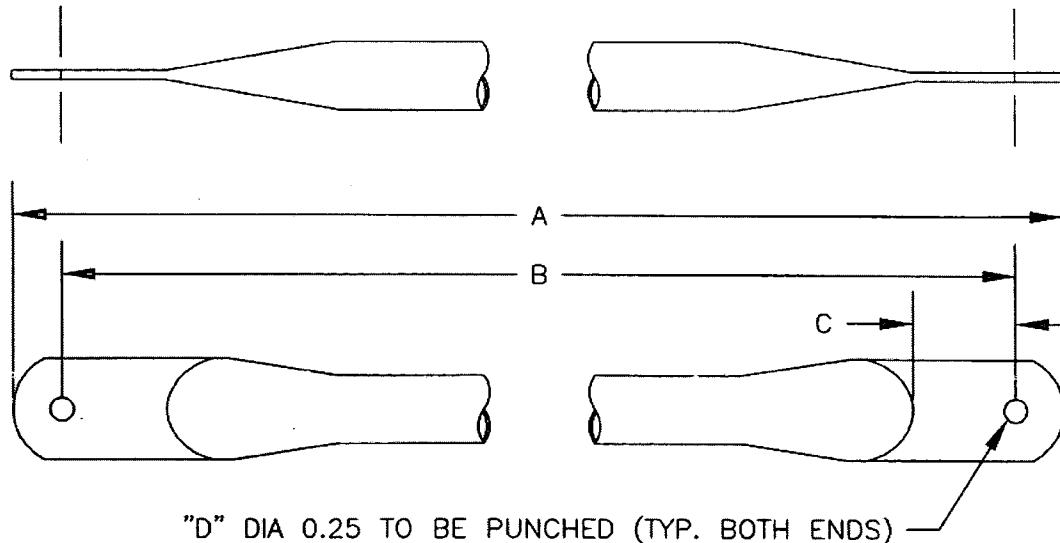
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WITHOUT NOTICE

WORK ORDER
NO. 33205



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

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NO. 33205

NOTE:

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 /E/

RELEASED
R
QA.05.11 KE

DART

ISSUED
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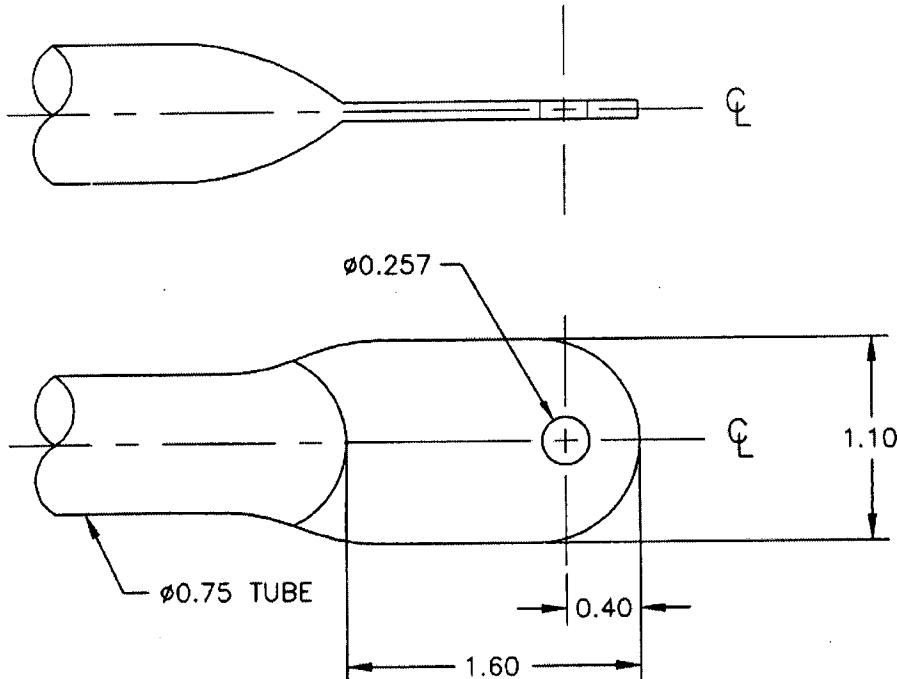
DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED KE	APPROVED W	DRAWING NO. D2017	REV. E	SHEET 2 OF 2
DATE 99.04.16	TITLE STEP STRUTS	SCALE NTS		

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DNY	APPROVED JF	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/09/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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